

Work Order ID 119325

Monday, July 14, 2014 11:16:46 AM

119325

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Item ID: D4526-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Tube Assembly

Start Date: 5/15/14 Start Qty: 8.00

8 1.0
8

Cust Item ID:

Required Date: 5/15/14 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 14-7-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4526	A								
100		0.00							
100						81			B. 5L.L. 12/07/15
Cold Saw	Memo	0.00							
Hyd Mech	CUT TO LENGTH AS PER DWG								
120	Manufacture as per dwg	0.00							
120						4			B. 5L.L. 12/07/15
Mill Conv	Memo	0.00							
Conventional Milling Machine	DRILL HOLES AS PER DWG								
130	QC6- Inspect dimensions to drawing	0.00							
130						1			
QC	Memo	0.00							
Quality Control									

Shp
4/7/16

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Item ID: D4526-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tube Assembly
 Start Date: 5/15/14 Start Qty: 8.00 ***g*** Cust Item ID:
 Required Date: 5/15/14 Req'd Qty: 8.00 ***g*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
140									
Large Fab	Memo	0.00							
Large Fab	1- WELD CAP AS PER DWG								
	2- GRIND ONLY THE ENDS FLUSH, TOP WILL BE MACHINE AS PER DWG								
150	QC10- Inspect visual per QSI004- ground welds	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Manufacture as per dwg	0.00							
160									
Lathe Conv	Memo	0.00							
Conventional Lathe	TURN ENDS AS PER DWG								

1 2 14.8.21

1 14.8.22

1 J.C.L. 14/08/22

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Item ID: D4526-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Tube Assembly
 Start Date: 5/15/14 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 5/15/14 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							① 14-08-22 D
180 *180* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							1 14-08-25
190 *190* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo PART MUST BE DRY INSIDE	0.00 0.00							1 14-08-25

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Item ID: D4526-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tube Assembly
 Start Date: 5/15/14 Start Qty: 8.00 ***g*** Cust Item ID:
 Required Date: 5/15/14 Req'd Qty: 8.00 ***g*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>ST254</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									
						<u>IX</u>	<u>DAS</u>	<u>28</u>	<u>AUG 25 2014</u>
							<u>9.89</u>		
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									
						<u>MLJ</u>	<u>1408-25</u>		

(Signature) 4-2.25

Picklist Print

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Parent Item: D4526-043

D4526-043

Parent Item Name: Tube Assembly

Start Date: 5/15/14

Required Date: 5/15/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 11.11.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W.188		Purchased	No			100	f	241.8263	2.3458	19.75411			

M6061T6T1 000W 188

6061T6 RD TUBE 1.00 X .188W

**

Location	Loc Qty	Loc Code
MAT016	81.7243	
- m128248	81.7243	
MAT030	160.102	
117797	19.25	
120935	0.461	
121848	48	
- 122114	15.121	
m126686	77.27	

7.08 + 2.4' 14/07/15

12.0

J.C.-L./A.A
14/07/14

D4526-3

Manufactured No

140 Each

21.0000

2

16

D4526-3

Cap

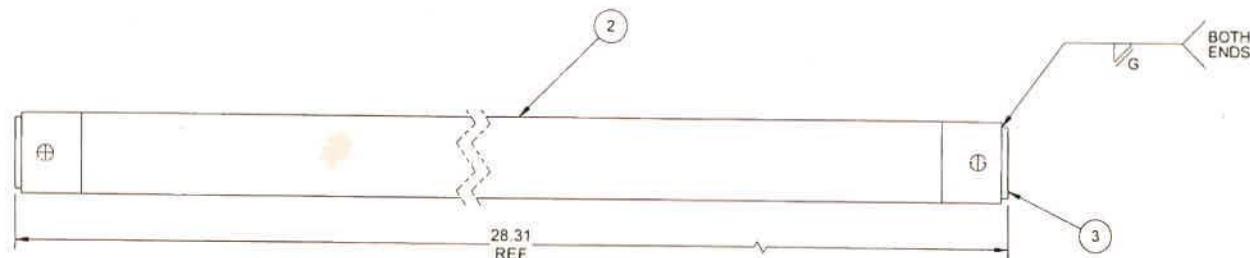
**

R 14-8-11

Location	Loc Qty	Loc Code
WA002	21	
82519	21	

2

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4526-043	TUBE ASSEMBLY
2	1	D4526-1	TUBING
3	2	D4526-3	CAP



D4526-043 TUBE ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

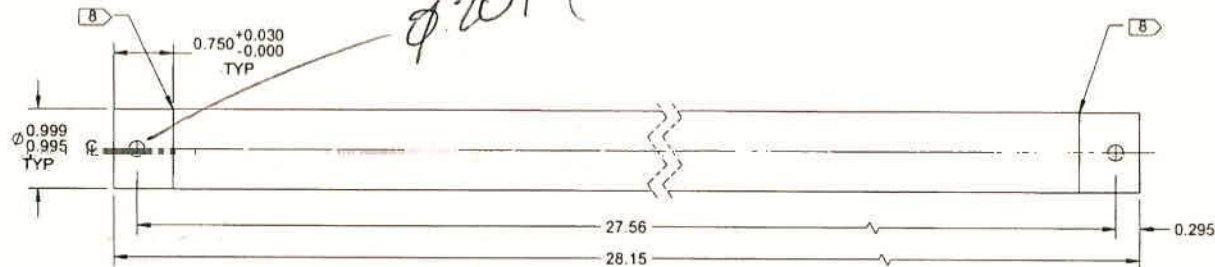
NO. 119325MD
14-717

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 1.32 lbs
- 8) WELD PER QSI 004

RELEASED
2011-11-28
JW

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4526	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR	<i>[Signature]</i>	MAINTENANCE STEP ASS'Y	NTS
DATE	11.11.22	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



D4526-1 TUBING

RELEASED
2011-11-28
MM

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T6T1.000W.188
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs
- 8) MIN RADIUS OF TRANSITION OF R0.06

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4526	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DC APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASS'Y	NTS
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Jean-Luc Menard

From: Roberto Fuentes
Sent: July-14-14 1:12 PM
To: Jean-Luc Menard; Harvey Siemens
Subject: holes diameter missing on the D4526 sheet 4

Hi JL,

In respond to your Skype message regarding holes diameter missing on the D4526 sheet 4. The holes are 0.201 in diameter according to the SW file, which is acceptable for a 10-32 screw.

Roberto